












Date: Thursday, 5/10/2007 2:23:43 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 32270	
Estimate Number : 12723	
P.O. Number : N/A	Part Number : D353613
This Issue : 5/10/2007 S.O. No. : N/A	Drawing Number : D3536 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : _____	Due Date : 5/17/2007
Checked & Approved By : <u>07.05.10</u>	Qty: 4 Um: Each
Comment : Est Rev: A New Issue 07-02-14 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	MNEO60S063 NEOPRENE SHEET 0.063
	 
Comment: Qty.: 0.8682 sf(s)/Unit Total : 3.4730 sf(s) NEOPRENE SHEET 0.063 Batch: <u>M103 104</u> <u>SAD</u> <u>07/04/12</u>	
2.0	WATER JET FLOW WATER JET
	 
Comment: FLOW WATER JET 1-Cut as per Dwg D3536 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary <u>SAD</u> <u>07/05/12</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAD</u> <u>07/05/12</u>	
4.0	QC8 SECOND CHECK
	 
Comment: SECOND CHECK <u>36</u> <u>07.05.12</u> (4)	
5.0	PACKAGING 1 PACKAGING RESOURCE #1
	 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>CU</u> <u>7/5/14</u> <u>59</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 12 Date: 07/05/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:23:43 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32270

Part Number: D353613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

12/27/03/14

Job Completion



OK 07-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

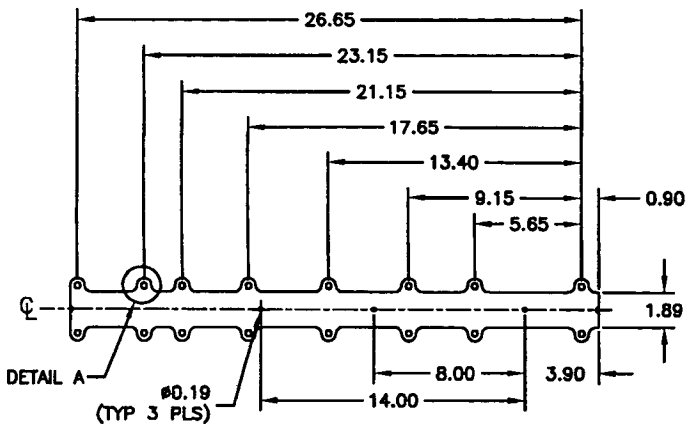
NOTE: Date & initial all entries

**DART**

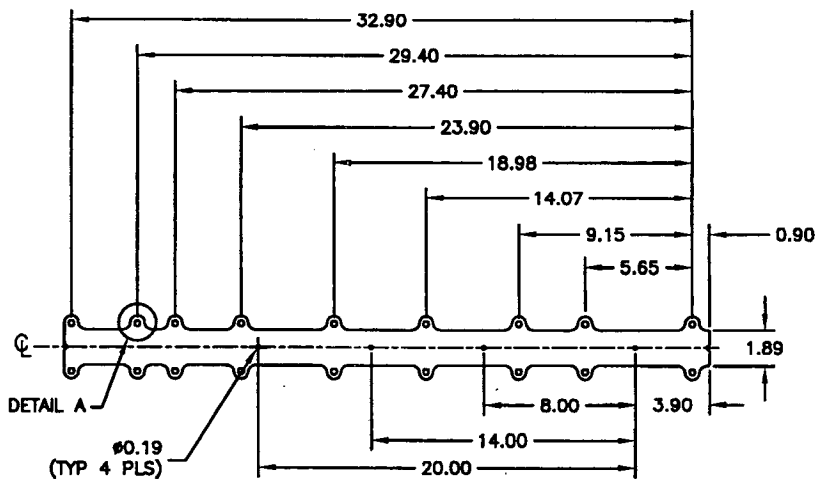
RELEASED

09.02.12-11

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10



**D3536-11 GASKET**



**D3536-13 GASKET**

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32270

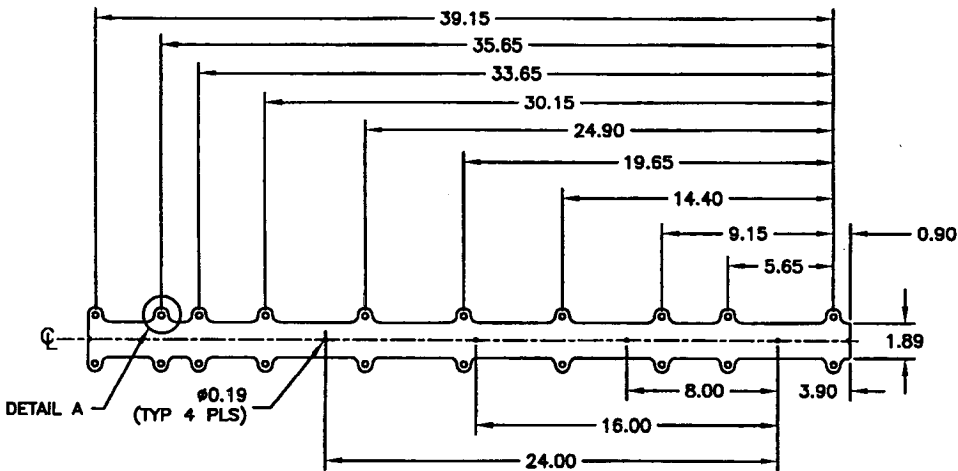
**NOTES:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

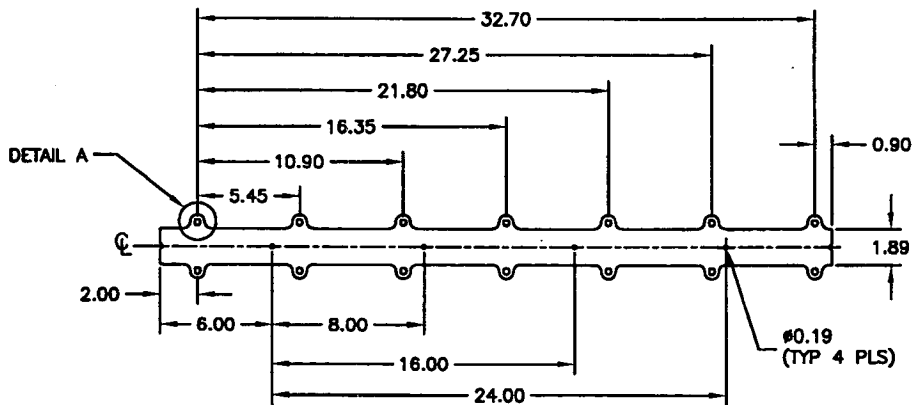
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CHECKED	PH	APPROVED	[Signature]	DRAWING NO.	REV. A
				D3536	SHEET 2 OF 6
DATE	06.10.25			TITLE	SCALE
				GASKET	1:10

07.02.12



**D35.36-15 GASKET**



**D3536-21 GASKET**

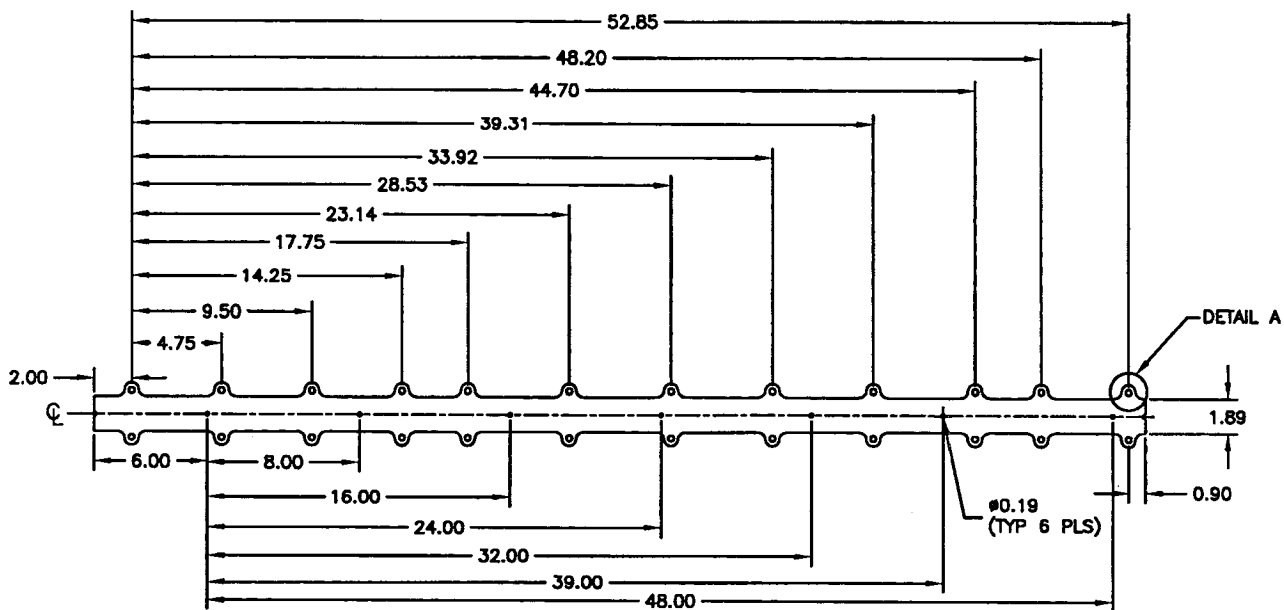
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DURETOMETER (REF DART SPEC. M-NEO60-S-063)
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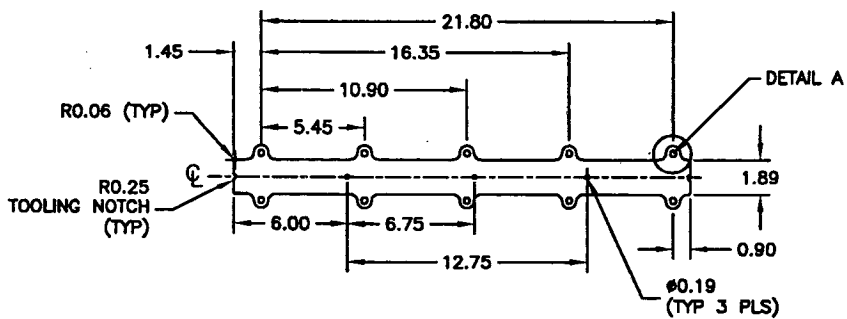
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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 3 OF 6
		SCALE	1:10	

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**D3536-23 GASKET**



**D3536-25 GASKET**

**NOTES**

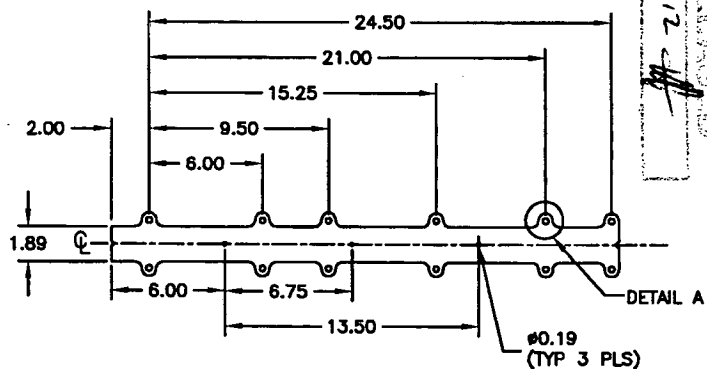
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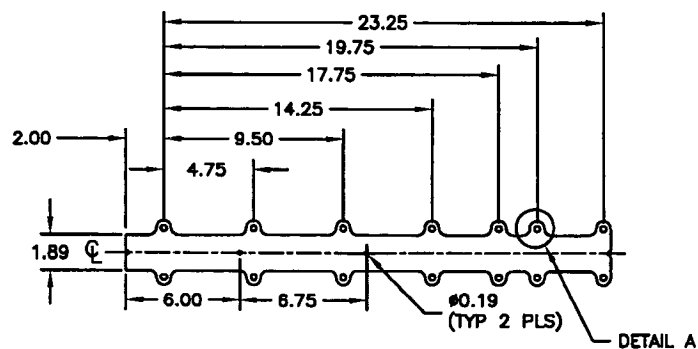
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 4 OF 6
		SCALE	1:10	

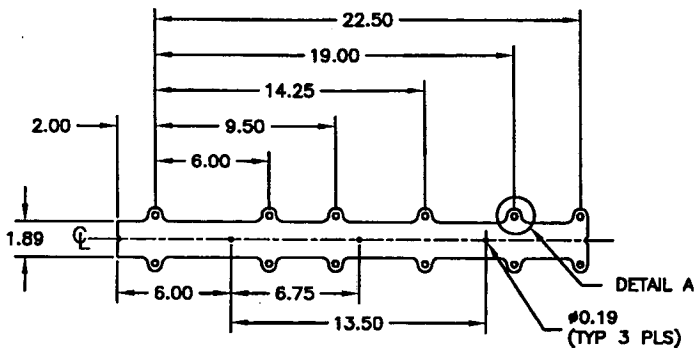
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**D3536-33 GASKET**



**D3536-35 GASKET**



**D3536-31 GASKET**

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**NOTES**

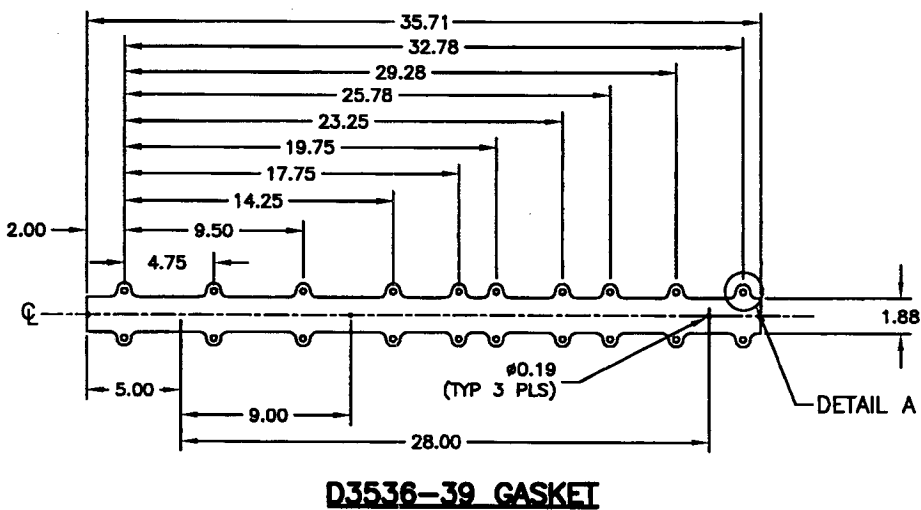
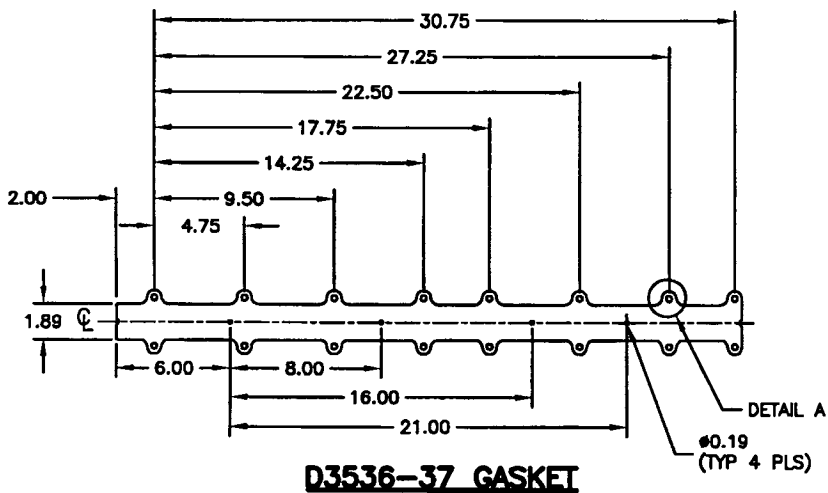
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**DART**

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DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10

07.02.12  
PH



**NOTES**

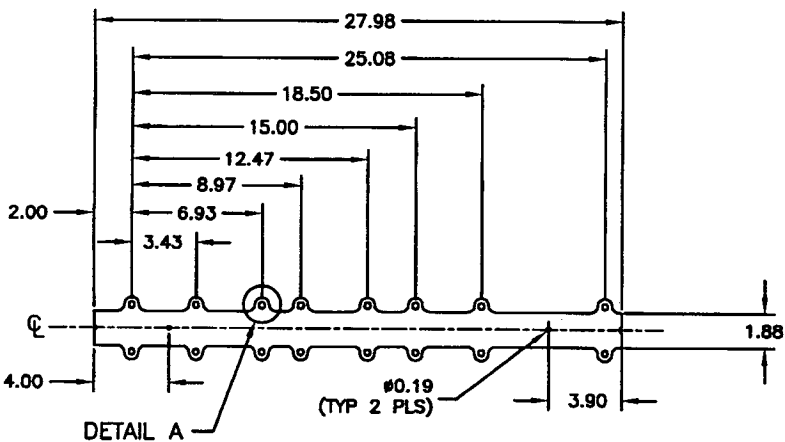
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# PART

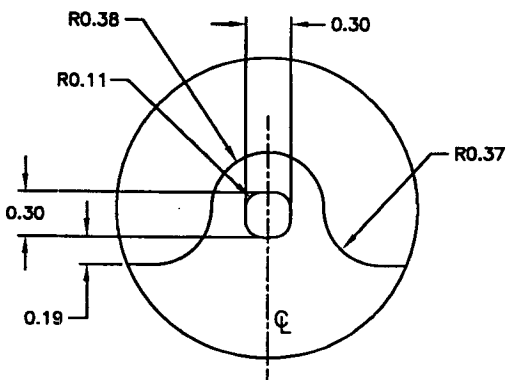
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CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH	[Signature]	D3536	SHEET 6 OF 6
DATE	TITLE		SCALE
06.10.25	GASKET		1:10

070612-4



**D3536-41 GASKET**

**DETAIL A**



## NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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WORK ORDER  
NO. 32270

DART AEROSPACE LTD		Work Order:	32270
Description: <del>Bear paw</del> GASKET		Part Number:	D353613
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	32.90	+/-0.030	32.90	✓		M-T	
B	29.40	+/-0.030	29.90	✓		M-T	
C	27.40	+/-0.030	27.40	✓		M-T	
D	23.90	+/-0.030	23.90	✓		M-T	
E	18.98	+/-0.030	19.98	✓		M-T	
F	14.07	+/-0.030	14.07	✓		M-T	
G	9.15	+/-0.030	9.14	✓		Vern	
H	5.65	+/-0.030	5.64	✓		Vern	
I	0.90	+/-0.030	0.89	✓		Vern/height gauge	
J	1.89	+/-0.030	1.89	✓		Vern	
K	3.90	+/-0.030	3.90	✓		Vern	
L	8.00	+/-0.030	7.98	✓		Vern	
M	14.00	+/-0.030	13.98	✓		Vern	
N	20.00	+/-0.030	19.99	✓		Vern	
O	20.19	+/-0.030	20.199	✓		Vern	
P	6.30	+/-0.030	6.30	✓		Vern	
Q	0.20	+/-0.030	0.31	✓		Vern	
R	0.063	+/-0.030					
S							
T							
U							
V							
W							
X							
Y							

Measured by: SAD	Audited by: <i>SG</i>	Prototype Approval:	N/A
Date: 07/05/12	Date: 07.05.12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	